

Work Order ID 128877

Tuesday, January 27, 2015 7:53:03 AM

128877

Page 1

Item ID: D206-802-119 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 5 Door Opener 206A/B Std Crew Door/Metal Baggage Door
 Start Date: 1/19/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: WLS Date: 15-01-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D407-802-2	A

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-119 CHG002								

105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									


 DAS 46 9-83
 FEB 19 2015
 DAS 46 9-83
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 DAS 46 9-83
 FEB 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128877***128877***

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Tuesday, January 27, 2015 7:53:03 AM

Item ID: D206-802-119

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 5 Door Opener 206A/B Std Crew Door/Metal Baggage Door

Start Date: 1/19/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-119								
	Location: <u>021</u>								
	PPP rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

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15/2/19

MF
15-2-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 128877

128877

Parent Item: D206-802-119

D206-802-119

Parent Item Name: 5 Door Opener 206A/B Std Crew Door/Metal Baggage Door

Start Date: 1/19/15

Required Date: 1/26/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC

IPP/Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-802-021		Manufactured	No			105	Each	1.0000	1	1			
D206-802-021	DAS								**				DAS
Crew Door Opener LH 206A/B	43												66
	9-89												9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG021		1							
				125938		1							
D206-802-022		Manufactured	No			105	Each	1.0000	1	1			
D206-802-022	DAS								**				DAS
Crew Door Opener RH 206A/B	46												66
	9-89												9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG021		1							
				101590		1							
D206-802-027		Manufactured	No			105	Each	0.0000	1	1			
D206-802-027	DAS								**				DAS
Passenger Door Opener LH 206A/B	46												66
	9-89												9-89
D206-802-028		Manufactured	No			105	Each	0.0000	1	1			
D206-802-028	DAS								**				DAS
Passenger Door Opener RH 206A/B	46												66
	9-89												9-89
D206-802-033		Manufactured	No			105	Each	1.0000	1	1			
D206-802-033	DAS								**				DAS
Baggage Door Opener Aluminum Door	43												66
	9-89												9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG021		1							
				104366		1							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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REFERENCE ONLY

FEB 19 2015

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IIN-D206-802-2

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5.5 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
☒	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

5.6 D206-802-119/-121/-123/-125/-127/-129 Combination Kits.

Qty -119	Qty -121	Qty -123	Qty -125	Qty -127	Qty -129	Part Number	Description
☒	☒	☒	☒	☒	☒	D206-802-119	5 DOOR OPENER KIT (STD CREW DOOR, MTL BAG)
☒	☒	☒	☒	☒	☒	D206-802-121	5 DOOR OPENER KIT (STD CREW DOOR, COMP BAG)
☒	☒	☒	☒	☒	☒	D206-802-123	5 DOOR OPENER KIT (HIGH VIS CREW DOOR, MTL BAG)
☒	☒	☒	☒	☒	☒	D206-802-125	5 DOOR OPENER KIT (HIGH VIS CREW DOOR, COMP BAG)
☒	☒	☒	☒	☒	☒	D206-802-127	4 DOOR OPENER KIT (STD CREW DOOR)
☒	☒	☒	☒	☒	☒	D206-802-129	4 DOOR OPENER KIT (HIGH VIS CREW DOOR)
1	1			1		D206-802-021	CREW DOOR OPENER KIT, LH
1	1			1		D206-802-022	CREW DOOR OPENER KIT, RH
		2	2		2	D206-802-023	HIGH VISIBILITY DOOR OPENER KIT, LH OR RH
1	1	1	1	1	1	D206-802-027	PASSENGER DOOR OPENER KIT, LH
1	1	1	1	1	1	D206-802-028	PASSENGER DOOR OPENER KIT, RH
1		1				D206-802-033	BAGGAGE DOOR OPENER KIT, METAL
	1		1			D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE

5.7 D407-802-211/-213/-215 Door Prop Kits.

Qty -211	Qty -213	Qty -215	Part Number	Description
☒	☒	☒	D407-802-211	DOOR PROP KIT
☒	☒	☒	D407-802-213	DOOR PROP KIT
☒	☒	☒	D407-802-215	DOOR PROP KIT
1			D3552-15	DOOR PROP
	1		D3552-17	DOOR PROP
		1	D3552-19	DOOR PROP

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Revision: A
Date: 10.10.13